

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008144**Date Inspected:** 07-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 3**Green Tags**

The following green tags issued for OBG components after completing the NDT requirements are:

1. LD009 – 008 – Green Tag # 010139
2. LD001 – 039 – Green Tag # 010127
3. LD007 – 010 – Green Tag # 010138
4. LD003 – 052 – Green Tag # 010136
5. LD004 – 054 – Green Tag # 010135
6. LD003 – 051 – Green Tag # 010144
7. LD003 – 053 – Green Tag # 010134
8. LD001 – 040 – Green Tag # 010128
9. LD013 – 014 – Green Tag # 010143
10. LD004 – 051 – Green Tag # 010150
11. LD003 – 054 – Green Tag # 010132
12. LD004 – 052 – Green Tag # 010133
13. LD012 – 020 – Green Tag # 010142

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- 14. LD005 – 010 – Green Tag # 010137
- 15. LD011 – 020 – Green Tag # 010141
- 16. LD002 – 040 – Green Tag # 010130
- 17. LD004 – 053 – Green Tag # 010134
- 18. LD010 – 008 – Green Tag # 010140
- 19. LD014 – 014 – Green Tag # 010145
- 20. LD017 – 021 – Green Tag # 010146
- 21. LD017 – 022 – Green Tag # 010147
- 22. LD018 – 021 – Green Tag # 010149
- 23. LD018 – 022 – Green Tag # 010148

BAY 6

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows:

- 1. ESD1 - SA4 - 61 -05 - Green Tag # 005861
- 2. ESD1-DPSA4-13B/B-27 - Green Tag # 005861
- 3. ESD1-DPSA4-13A/B-04 - Green Tag # 005861
- 4. ESD1-DPSA4-13B/B-01 - Green Tag # 005861
- 5. ESD1-DPSA4-13B/B-10; 15; 18 - Green Tag # 005861
- 6. ESD1-DPSA4-12A/B-5 - Green Tag # 005862
- 7. ESD1-DPSA4-12B/B-26 - Green Tag # 005862
- 8. ESD1-SA4-60-05 - Green Tag # 005862
- 9. ESD1-DPSA4-12B/B-02 - Green Tag # 005862
- 10. ESD1-DPSA4-12B/B-10; 15; 18 - Green Tag # 005862
- 11. SSD1-DPSA4-7A/B-06 - Green Tag # 005860
- 12. SSD1-DPSA4-7B/B-01 - Green Tag # 005860
- 13. SSD1-SA4-52-06 - Green Tag # 005860
- 14. SSD1-DPSA4-7B/B-27 - Green Tag # 005860
- 15. SSD1-DPSA4-7B/B- 10; 15; 18 - Green Tag # 005860

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #7A located on WD1 – A305 – 77M – 3. Welder is identified as 066456. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #18 located on WD1 – A305 – 77M – 4. Welder is identified as 066459. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #1B located on WD1 – A305 – 77M – 3. Welder is identified as 066457. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the

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WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #8A located on WD1 – A305 – 65M – 1. Welder is identified as 066481. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

BAY 7

This QA Inspector observed the following work in progress:

SAW process of weld joint #015 located on EP3001 – 001. Welder is identified as 054458. ZPMC QC is identified as Zhang Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

SAW process of weld joint #015 located on EP3007 – 001. Welder is identified as 054458. ZPMC QC is identified as Zhang Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

BAY 8

This QA Inspector observed the following work in progress:

FCAW process of weld joint #001 located on Cross Beam CB202B – 013. Welder is identified as 069118. ZPMC QC is identified as Guo Yan Tei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

SAW process of weld joint #001 located on Cross Beam CB202F – 013. Welder is identified as 207463. ZPMC QC is identified as Guo Yan Tei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Prue,Erik

QA Reviewer